

Date: Thursday, 2/14/2008 11:01:30 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: PANEL		
Job Number	: 37440			Part Number	: D33301		
Estimate Number	: 10769			Drawing Number	: D3330 REV D		
P.O. Number	:			Project Number	: N/A		
This Issue	2/14/2008	S.O. No.	:	Drawing Revision	: D		
Prsht Rev.	: NC			Material	:		
First Issue	/: /	Type	: SMALL /MED FAB	Due Date	3/15/2008	Qty:	6
Previous Run	: 35482			Um:	Each		
Written By	:						
Checked & Approved By	:						
Comment	: Est: A 05-01-13 New issue KJ/JLM Est Rev: B Now on Waterjet 06-09-25 JLM est C 07-05-14 rev c dwg ec EST: D 07-12-12 revD dwg EC verified by: DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125
		 Comment: Qty.: 1.1445 sf(s)/Unit Total : 6.8670 sf(s) 1010-1025 sheet .125 Batch: 106140 <b>HR 8-2-21</b>
2.0	WATER JET	FLOW WATER JET
		 Comment: FLOW WATER JET 1-Cut as per Dwg D3330 Dwg Rev: <b>D</b> <b>HR 8-2-21</b> Prog Rev: <b>D</b> <b>(6)</b>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		 <b>HR 8-2-21</b>
4.0	QC8	SECOND CHECK
		 <b>10612-25(6)</b>
5.0	BRAKE NC	NC BRAKE
		 Comment: NC BRAKE Form as per Dwg D3330 <b>SB 08/03/01</b>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 08/03/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 11:01:30 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 37440

Part Number: D33301

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



8 08/03/12 46

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 488

JS 08/03/12 (X6)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(b)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/12

Job Completion



2008/3/12

(6)

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37440
Description: Panel	Part Number:	D3330-1
Inspection Dwg: D3330	Rev: 02	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

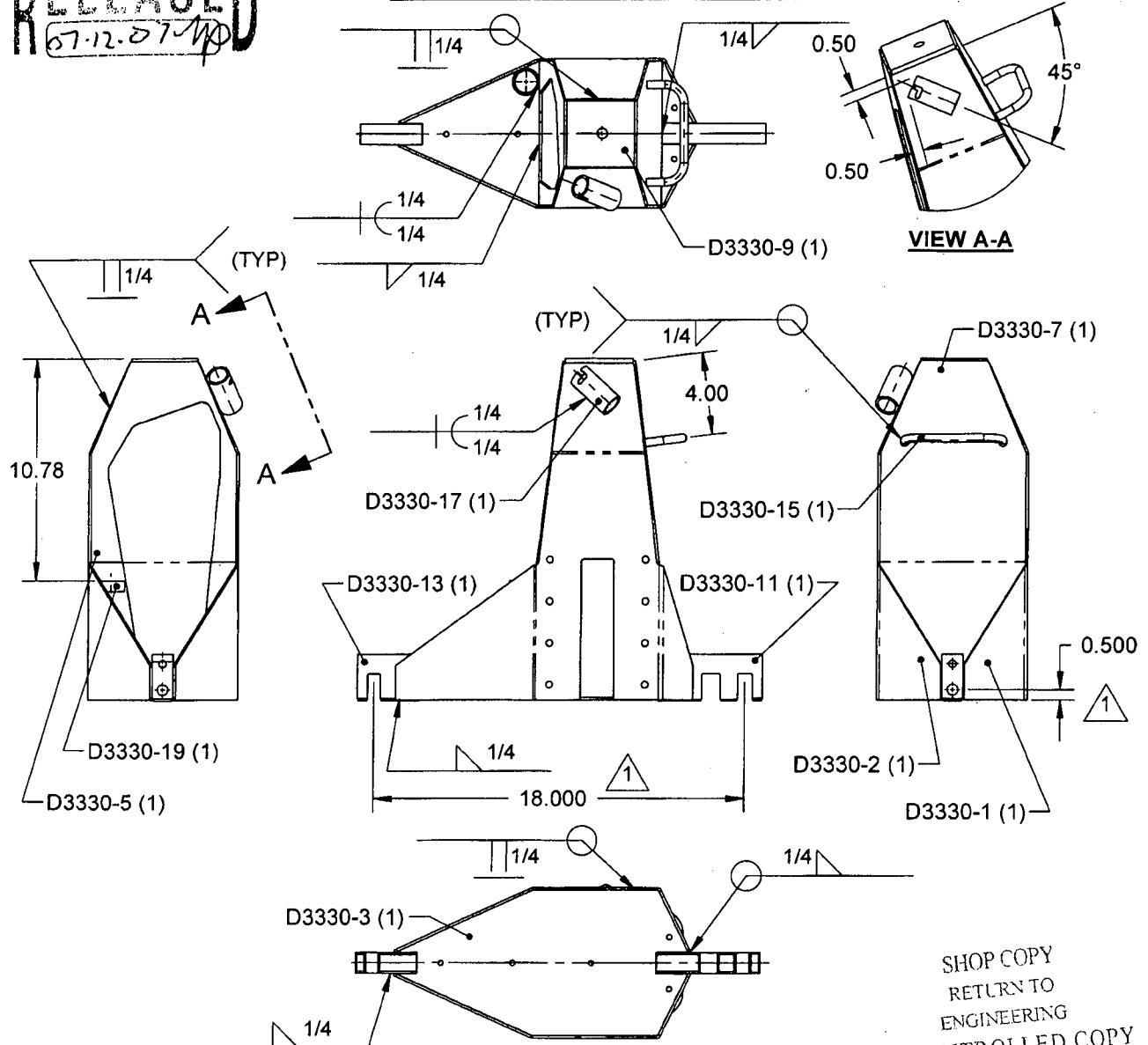
Measured by:	HB	Audited by:		Prototype Approval:	N/A
Date:	8-2-21	Date:	2021-25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	
B	07.05.16	Dwg Rev updated	KJ/EC	EE

14

**DART**

DESIGN 13	DRAWN BY DC	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED 13	APPROVED MW	DRAWING NO. D3330
DATE 07.12.06		REV. D SHEET 1 OF 9 TITLE <b>FRAME WELDMENT</b> SCALE 1:8

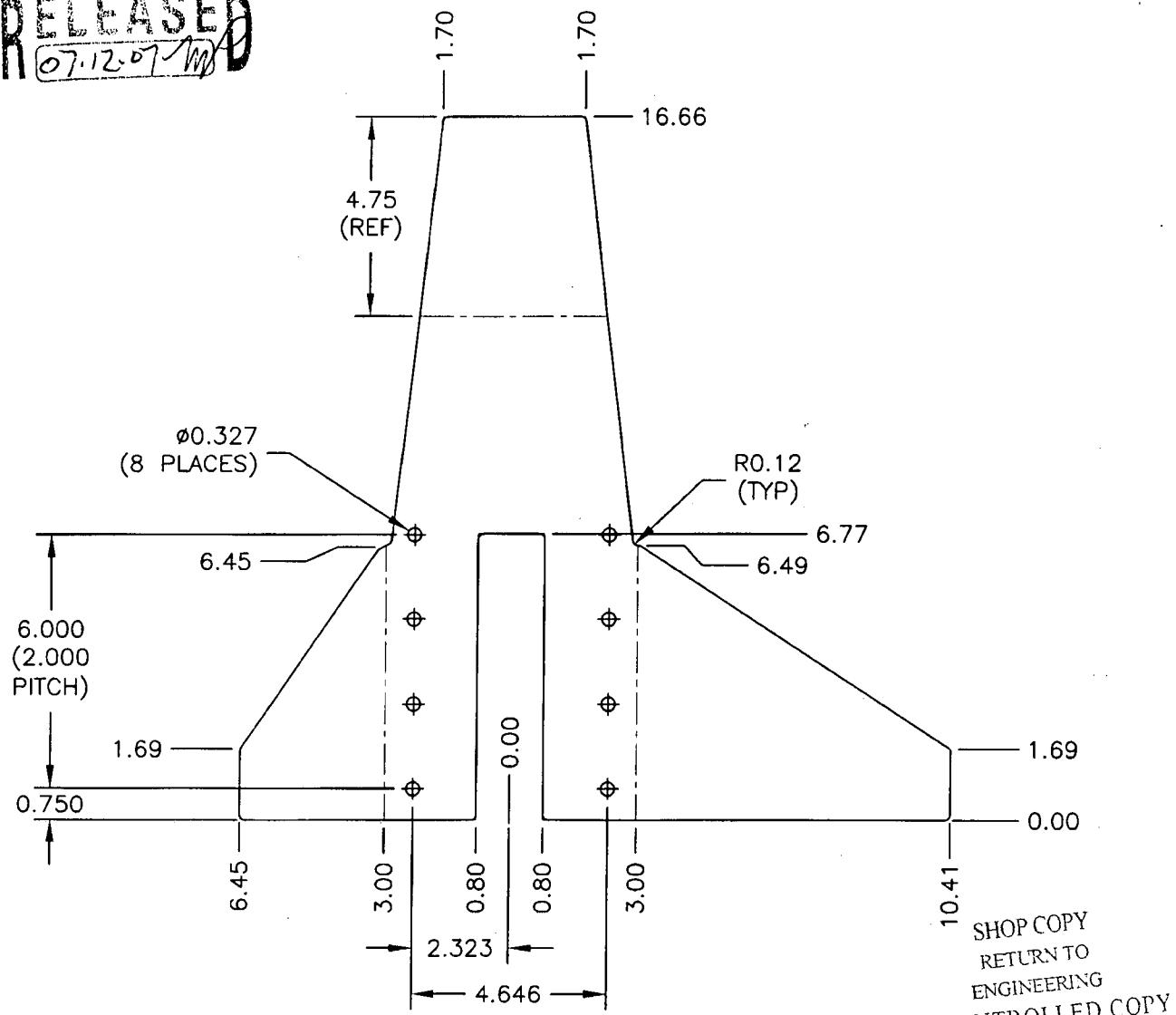
**RELEASED**  
07.12.07 MJD**D3330-041 FRAME WELDMENT****NOTES:**

- 1) POSITION PARTS AS PER JIG D3330-041T1
- 2) WELD PER QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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WORK ORDER  
NO. 37440

**DART**

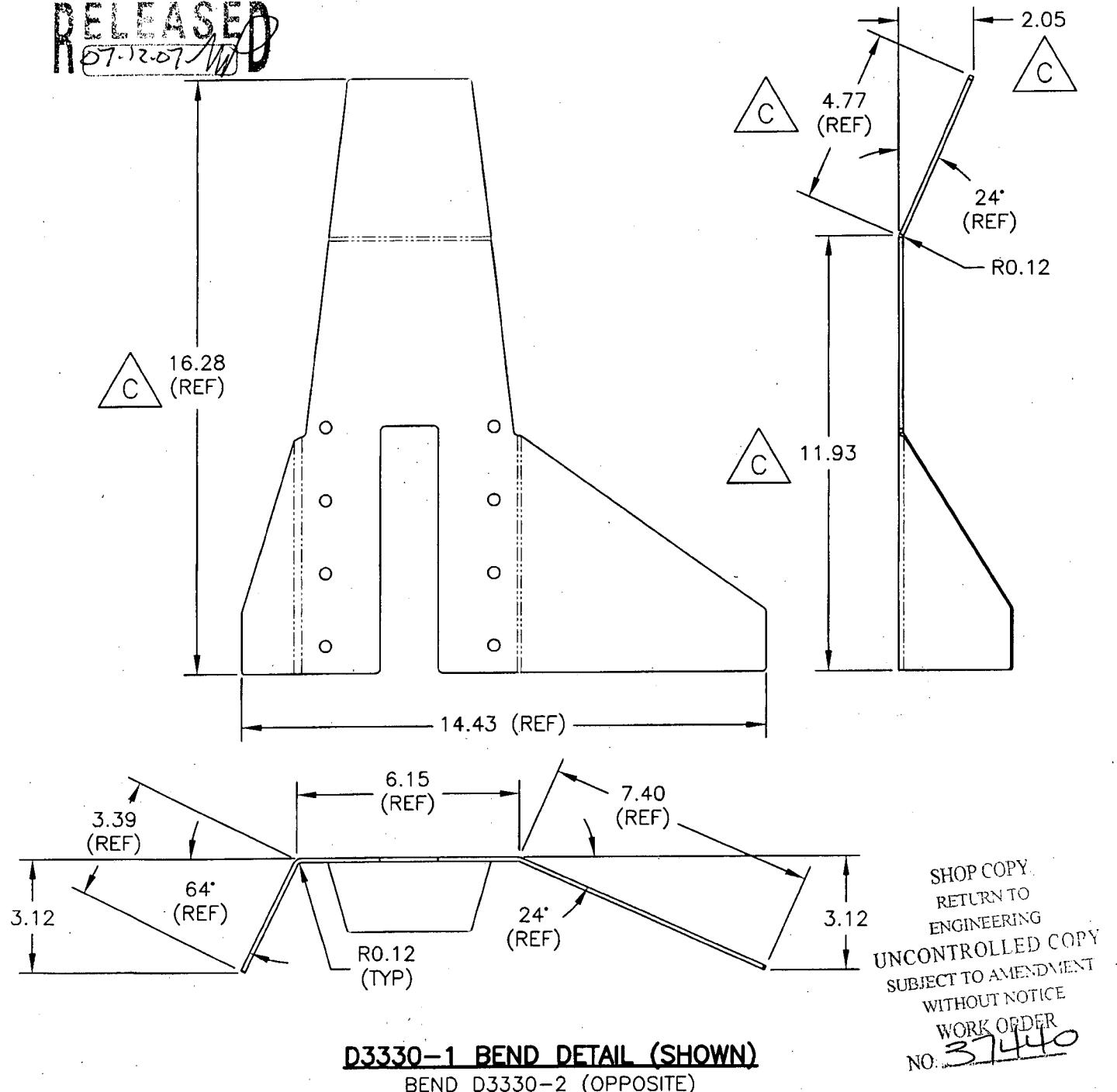
DESIGN <i>BS</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>BS</i>	APPROVED <i>W</i>	DRAWING NO. D3330	REV. D SHEET 2 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

**RELEASED**  
07.12.07 *WAD***D3330-1 PANEL****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**DART**

DESIGN HB	DRAWN BY SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JL	APPROVED NP	DRAWING NO. D3330	REV. D SHEET 3 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

**RELEASED**  
07-12-07 MD**D3330-1 BEND DETAIL (SHOWN)**

BEND D3330-2 (OPPOSITE)

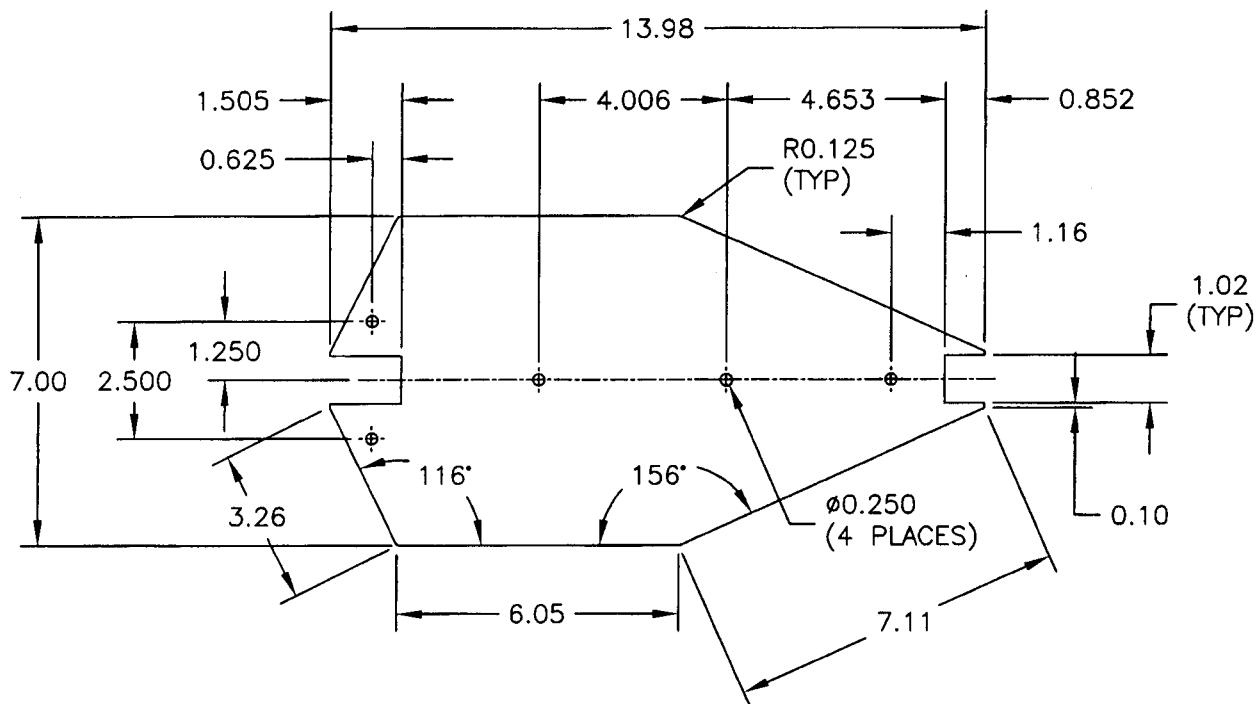
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CHECKED <i>B</i>	APPROVED <i>MM</i>	DRAWING NO. D3330	REV. D	SHEET 4 OF 9
DATE 07.12.06	TITLE FRAME WELDMENT		SCALE 1:4	

RELEASED  
07-12-07 *[Signature]*



D3330-3 PLATE

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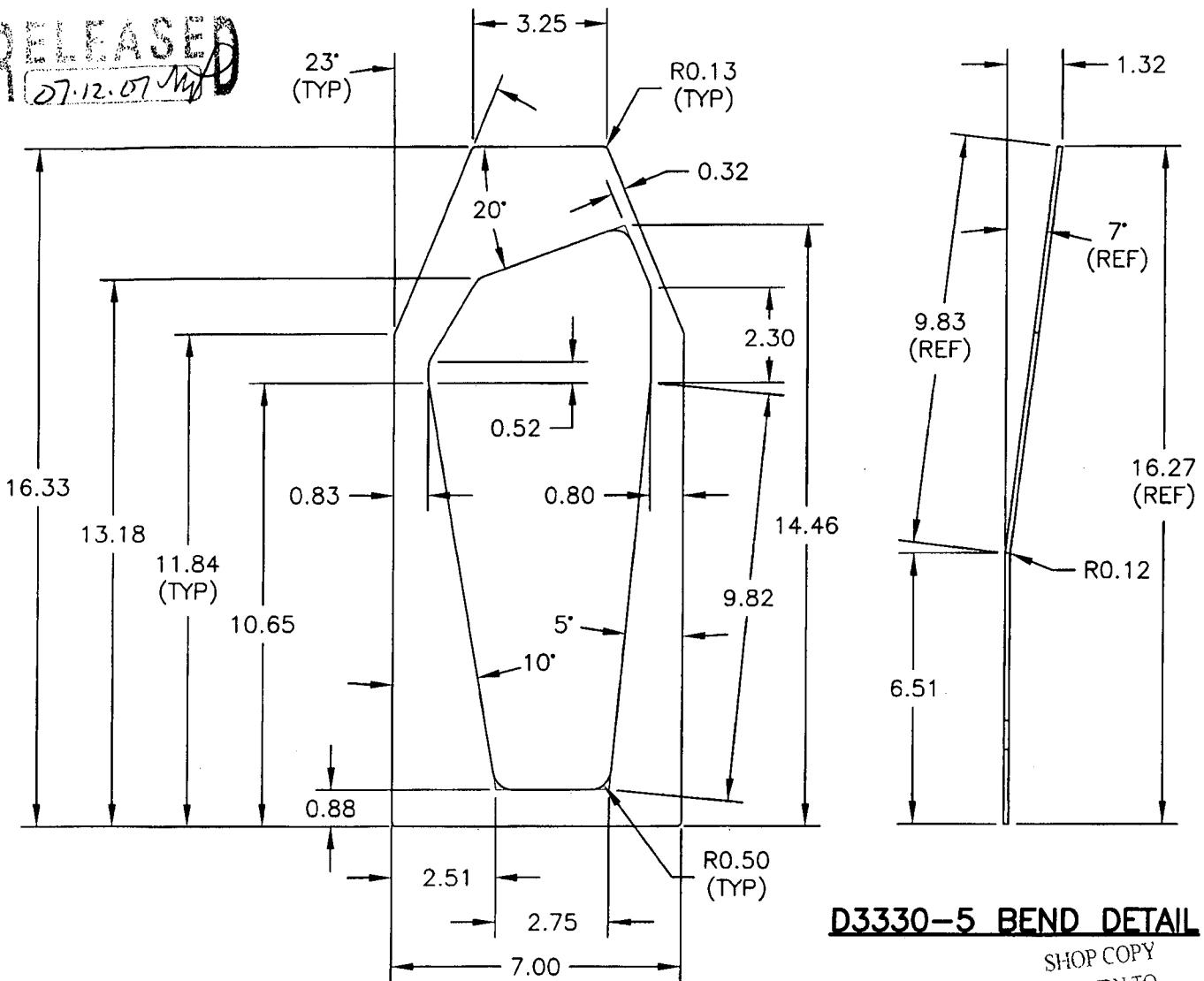
## NOTES:

NOTES

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**DART**

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CHECKED <i>B</i>	APPROVED <i>M</i>	DRAWING NO. D3330	REV. D SHEET 5 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:4

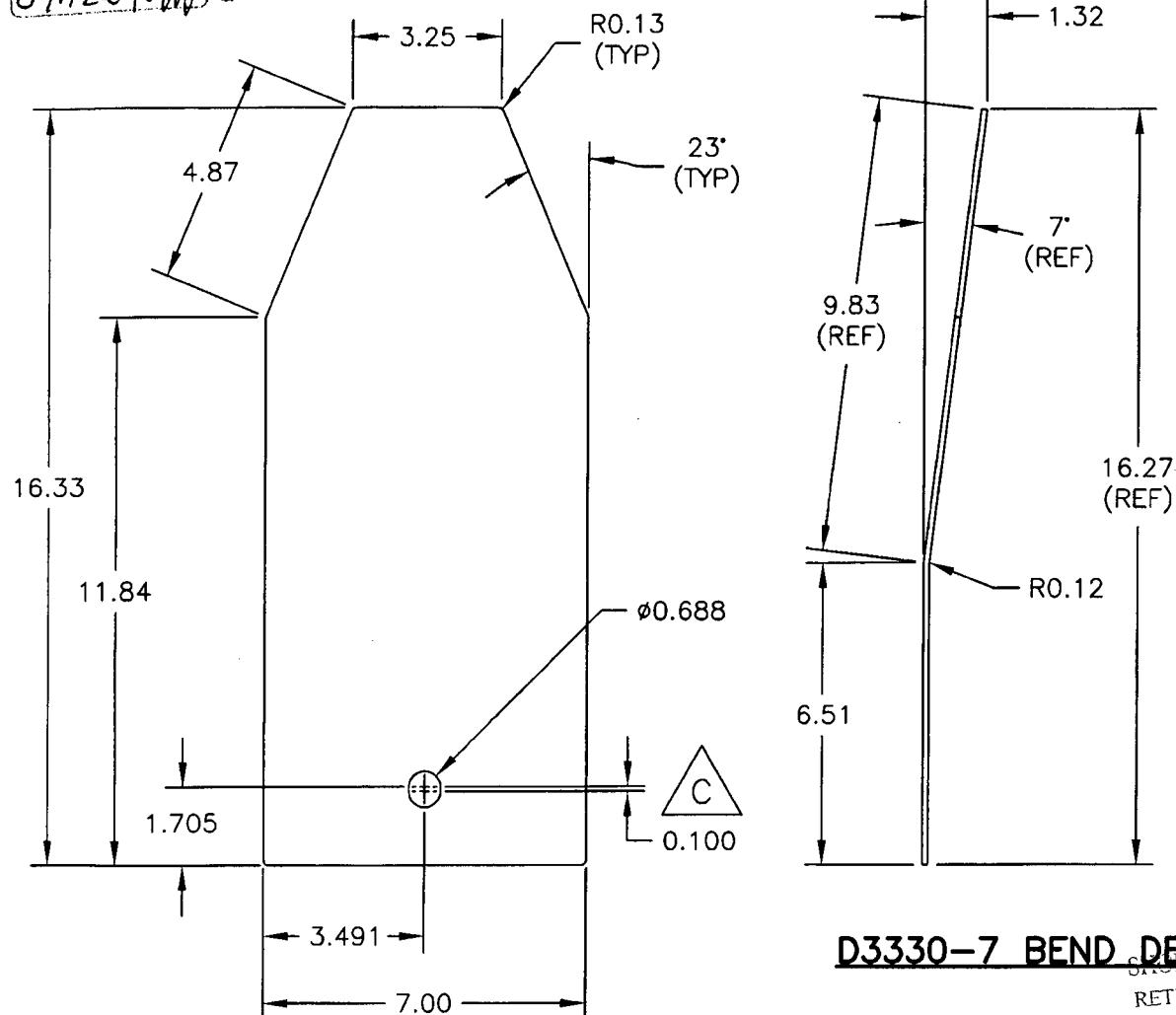
**RELEASED**  
(07.12.07 M)**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED <i>AS</i>	APPROVED <i>NP</i>	DRAWING NO. D3330	REV. D SHEET 6 OF 9
DATE 07.12.06		TITLE FRAME ASSEMBLY	SCALE 1:4

**RELEASED**  
*07.12.07/MWD***D3330-7 BEND DETAILS**

SHEET 6 OF 9

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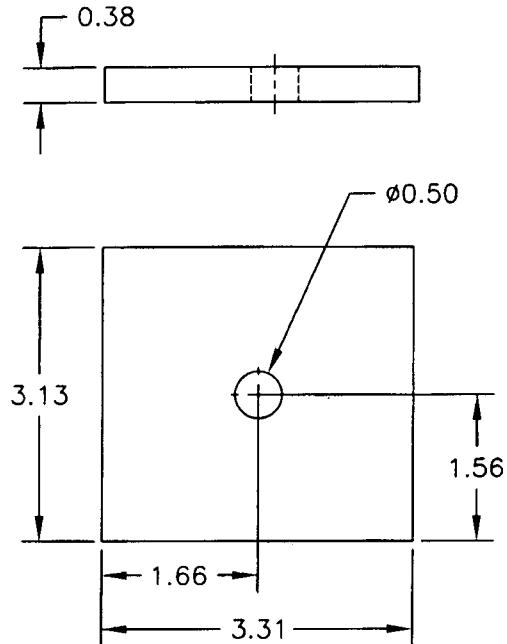
NO. *37440***NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

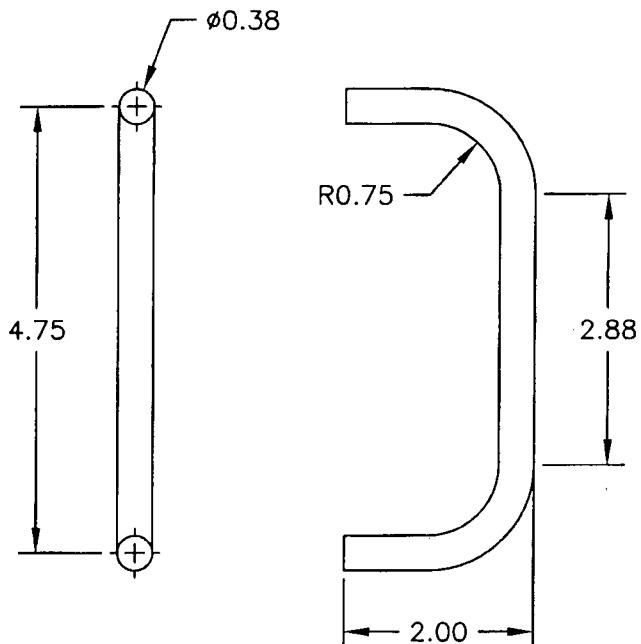
**DART**

DESIGN <i>B</i>	DRAWN BY <i>DCP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>J</i>	APPROVED <i>M</i>	DRAWING NO. D3330	REV. D SHEET 7 OF 9
DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:2

RELEASED  
(07.12.07) *WAD*



△ D3330-9 TOP PLATE



△ D3330-15 HANDLE

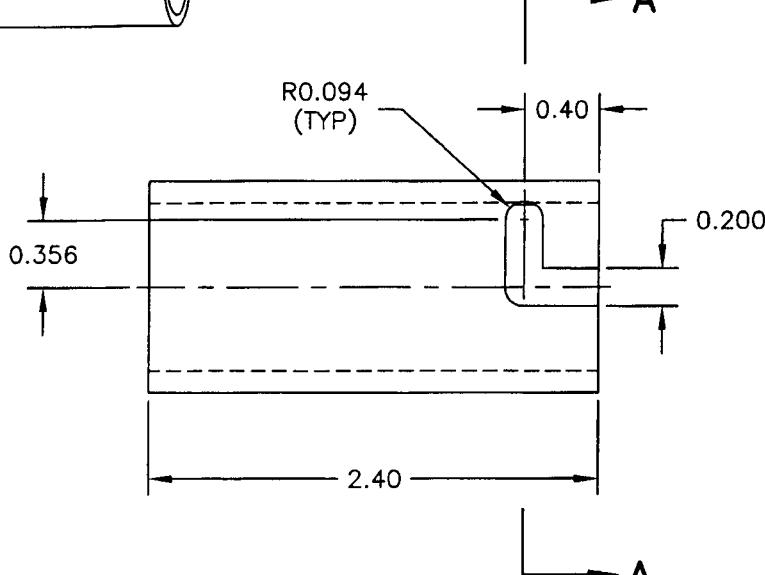
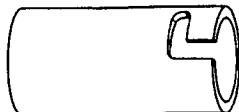
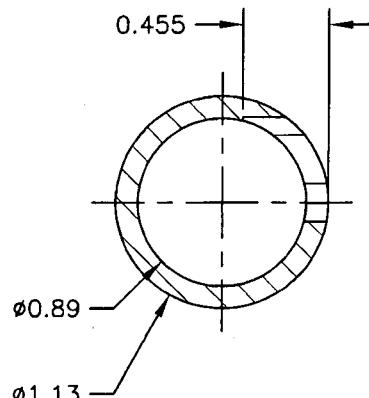
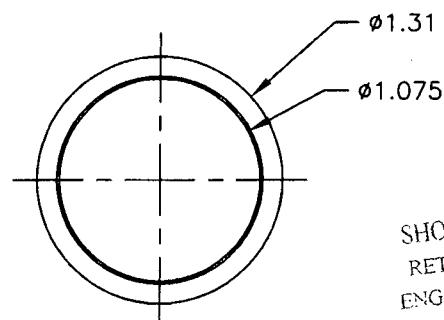
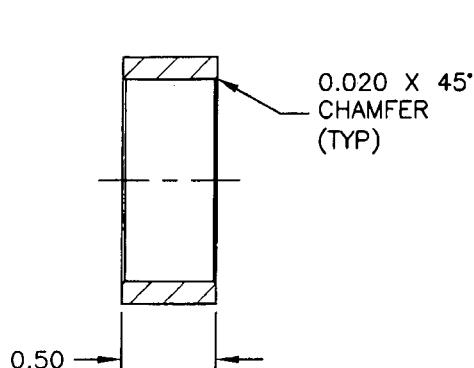
NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL  
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097  
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 07.12.06		TITLE FRAME WELDMENT	SCALE 1:1

**RELEASED**  
*07.12.07 MP***SECTION A-A****D3330-17 HANDLE SOCKET**

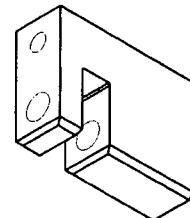
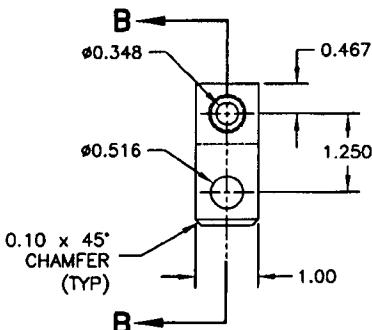
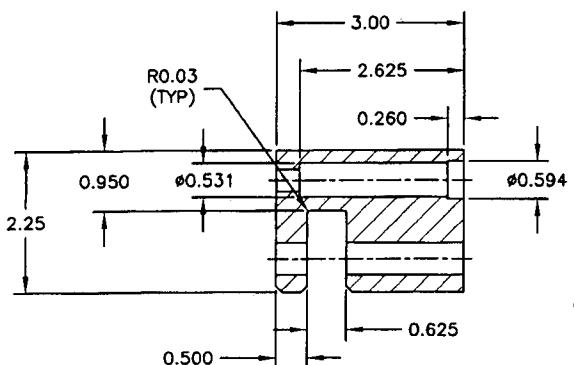
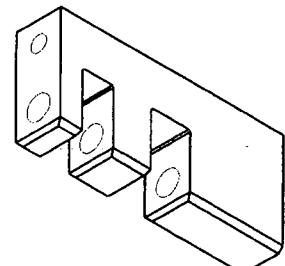
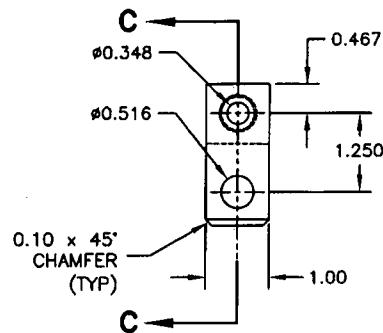
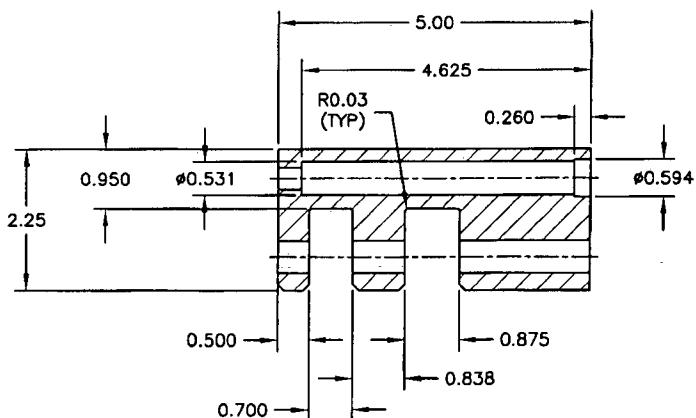
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NO. *37440*

**D3330-19 HANDLE RIM****NOTES:**

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097  
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
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DATE		DRAWING NO.	REV. D
		D3330	SHEET 9 OF 9
07.12.06		TITLE	SCALE
		FRAME WELDMENT	1:3

**SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK STEEL (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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